

Date: Monday, 12/03/2007 12:39:16 PM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: R44 WEARPLATE
Job Number	: 31166		
Estimate Number	: 12651		
P.O. Number	: N/A	Part Number	: D35651
This Issue	: 12/03/2007	Drawing Number	: D3565 UNDER REVIEW
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: U/R
Previous Run	: 30312	Material	: N/A
Written By	:	Due Date	: 16/03/2007
Checked & Approved By	:	Qty:	1 Um: Each
Comment	: Est Rev :A New Issue 07-01-16 JLM		
Additional Product			
Job Number:			
Seq. #:	Machine Or Operation:	Description :	
1.0	M304S20GA	304/316 .040 Sheet	
			
Comment: Qty.: 0.3759 sf(s)/Unit Total : 0.3759 sf(s) 304/316 .040 Sheet 7518 Batch: m101463 ml 07 03 14 (2)			
2.0	WATER JET	FLOW WATER JET	
			
Comment: FLOW WATER JET 1-Cut as per Dwg D3565 Dwg Rev: Prel Prog Rev: Prel ml > 01 03 14 (2) 2-Deburr if necessary mn			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
	 ml 07 03 14		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE			
4.0	QC8	SECOND CHECK	
	 J0703-14		
Comment: SECOND CHECK			
5.0	BRAKE NC	NC BRAKE	
	 NK		
Comment: NC BRAKE form 90 deg bend as per Dwg D3565			

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Eng Approval
CB 07.03.21

Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP <i>Step 6 QC5 (2)</i>
7.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 <i>Step 7 Small Fab 1 (2)</i>
		Comment: SMALL & MEDIUM FAB RESOURCE 1
		1-Form "Cups" using DT8902 FORMING TOOL.
		2-Oen Holes to .257" as per Dwg D3565, after forming. <i>SB 07/03/14 (2)</i>
8.0	QC5	INSPECT WORK TO CURRENT STEP <i>Step 8 QC5 (2)</i>
		Comment: INSPECT WORK TO CURRENT STEP
9.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1 <i>Step 9 Large Fab 1 (2)</i>
		Comment: LARGE FABRICATION RESOURCE 1 Weld hard facing as per Dwg D3565 using DT8903 Holding Plate <i>FC 07/03/22 (2) Hard Facing</i>
	A/R 2059B Hard Coatrod	Batch: M02755 <i>M02755 (2)</i>
10.0	QC5/9	WELD INSPECTION <i>Step 10 QC5/9 (2)</i>
		Comment: WELD INSPECTION
11.0	POWDER COATING	POWDER COATING <i>Step 11 Powder Coating (2)</i>
		Comment: POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3.
12.0	QC3	INSPECT POWDER COAT/CHÉMICAL CONVERSION <i>Step 12 QC3 (2)</i>
		Comment: INSPECT POWDER COAT/CHÉMICAL CONVERSION <i>EC 07.03.23 (2)</i>
13.0	PACKAGING 1	PACKAGING RESOURCE #1 <i>Step 13 Packaging 1 (2)</i>
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____

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14.0	QC21	FINAL INSPECTION/W/O RELEASE
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07/03/07 SP
07/03/07

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U J.F.B.(h)

Job/Project Number: 00062

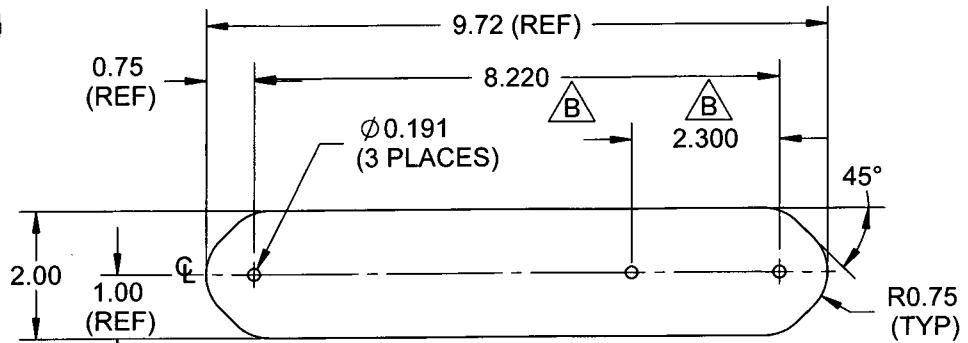
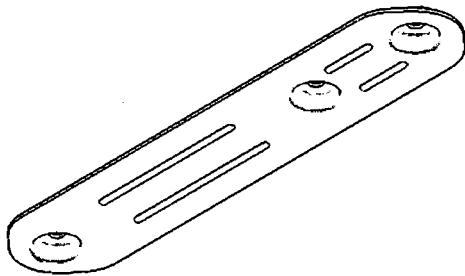
Design Engineer/Project Manager Signature: CB Date: 07.03.12

Design Manager Signature: _____ Date: 07.03.12

PROTOTYPE REQUEST FORM

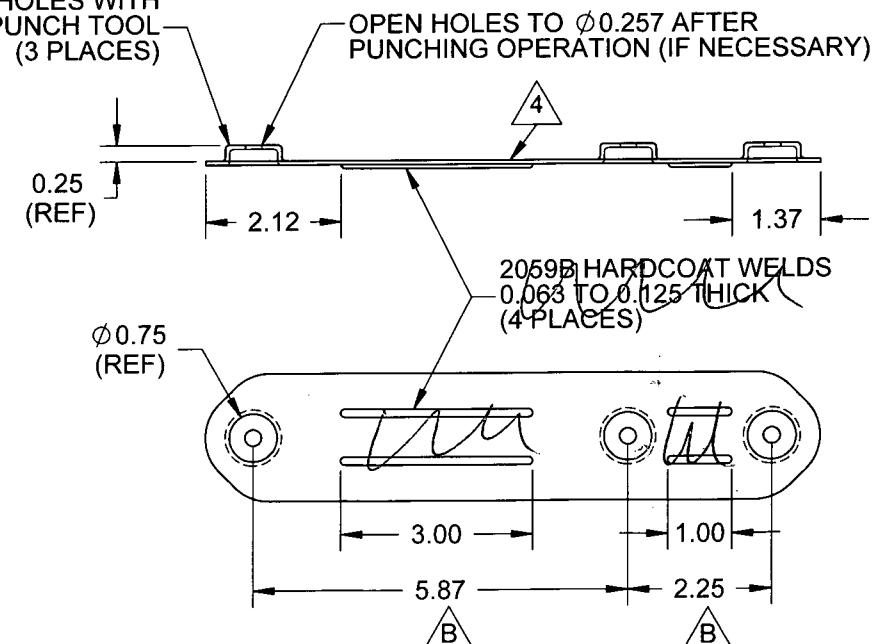
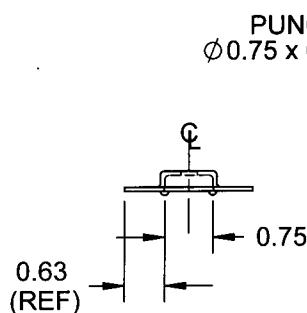
PRELIMINARY ISSUE

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3565	
DATE 07.03.12	TITLE R44 WEARPLATE	SCALE 1:3	REV. B SHEET 1 OF 1
REV A	DATE 07.01.09	DESCRIPTION NEW ISSUE	
REV B	DATE 07.03.12	DESCRIPTION 8.220 WAS 8.120; 2.300 WAS 2.250; ADD HOLE DIMS AFTER CUP FORMING	



UNDER REVIEW
67.03.12 CB
prototype

D3565-1F FLAT PATTERN



Do not weld
or powder
coat

D3565-1 R44 WEARPLATE

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE (0.063 THICK) (REF DART SPEC M304S16GA)
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3565-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) WELD PER QSI 004
- 8) PART IS SYMMETRIC ABOUT φ

DART AEROSPACE LTD	Work Order:	31166
Description: R44 - Nearplate	Part Number:	D3565-1
Inspection Dwg: D3565 Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Measured by:	Audited by:	Prototype Approval:
Date: 07 03 14	Date: 07 03 14	Date:

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/JLM	